

Work Order ID 51425

August 24, 2009 10:26:40 AM



Page 2

Item ID: D2274	Accept		Setup	Start	
Revision ID: F				Stop	
Item Name: Radius Block					
Start Date: 24/08/2009	Start Qty: 300.00		Cust Item ID:		
Required Date: 28/08/2009	Req'd Qty: 300.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Tumble <input type="checkbox"/> Deburr any rough edges after tumbling								
150	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

N.A 09/08/25

324

✓

M-L 09/09/01

324X

B9-9-2

34

MD 09/09/08

X324

Work Order ID 51425

August 24, 2009 10:26:40 AM



Page 3

Item ID: D2274

Accept



Setup Start



Revision ID: F

Stop



Item Name: Radius Block

Start Date: 24/08/2009 Start Qty: 300.00



Cust Item ID:

Required Date: 28/08/2009 Req'd Qty: 300.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev. Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

01-09-9

324

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

09/09/9 324

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/09/09 324
MF 09-09-09

Picklist Print

August 24, 2009 10:26:40 AM

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Parent Item: D2274RevF



Parent Item Name: Radius Block

Start Date: 24/08/2009

Required Date: 28/08/2009

Comments:

Start Qty: 300.00

Required Qty: 300.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	91.9697	28.9263			



DF 09/08/24



6061-T6 Bar .750 x .125

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	91.9697	
104725	7.52	
105061	11.4	
109760	16.25	
110591	56.7997	

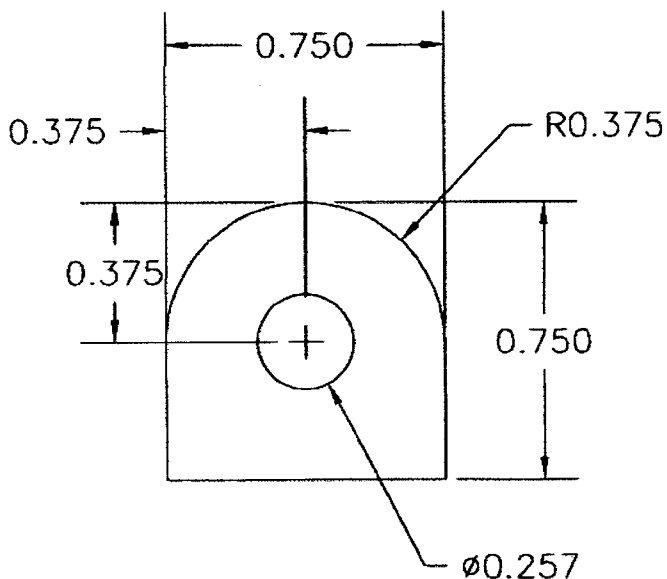
28.9263



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	

RELEASED
98/08/18 KE

u/p 51425



0.005.16
0.005.16
0.063 x 45° CHAMFER
R0.0 - 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED